

Work Order ID 87072

87072

Page 1

July-10-12 2:50:09 PM

Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Float Skidtube
 Start Date: 7/10/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/31/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: 20711 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-043 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-742-043 CHG005



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87072***87072***

Page 2

July-10-12 2:50:09 PM

Item ID: D412-742-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Float Skidtube

Start Date: 7/10/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/31/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/RSikaflex-241/-291 M122443
Expiry date: 13103

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 M122443
Expiry date: 13103

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/RLPS Procyon M114591

1x 4 M 12/08/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

DAS 16 8-3 12/6/12

APP 87091

12/8/12

ML5 12108130

MF 120830

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 2:50:08 PM

Page 1
3

Work Order ID: 87072

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 7/10/12

Required Date: 8/31/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517
 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 Fwd Tube Assembly		Manufactured	No			110	Each	0.0000					
D3391-023 Mid Tube Assembly		Manufactured	No			110	Each	2.0000					
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				FP		3							
				83625		1							
				GA		-1							
				85163		1							
D3391-025 Aft Tube Assembly		Manufactured	No			110	Each	2.0000					
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				FP001		2							
				84702		1							
				86183		1							
AN3C4A BOLT		Purchased	No			110	Each	3,664.0000	24	24			
				<u>Location</u>		<u>Loc Qty</u>				<u>Loc Code</u>			
				ST350		3664							
				120187		31							
				120521		28							
				120769		38							
				121205		67							
				121556		8							
				122151		3492							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 87072

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 7/10/12

Required Date: 8/31/12

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No

110 Each 269.0000

10

10

12/08/24

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	268	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	118	
121682	58	

X10

AN3C7A Purchased No

110 Each 184.0000

4

4

12/08/24

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	184	
113149	14	
116169	1	
117313	10	
117619	12	
117688	6	
119749	1	
120731	8	
121185	30	
121541	2	
122141	100	

X4

July-10-12 2:50:08 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July-10-12 2:50:08 PM

Page 3

Work Order ID: 87072

Parent Item: D412-742-043

Start Date: 7/10/12

Required Date: 8/31/12

Parent Item Name: Replacement Float Skidtube

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332R

Purchased

No

110

Each

21.0000

38

38

washer

11 122063 (x38) 11 12/08/12

Location

Loc Qty

Loc Code

ST

21

107534

21

D4095-041

Manufactured

No

110

Each

9.0000

Wearplate Assembly

1 1385616 (x1) 1 11/08/12

Location

Loc Qty

Loc Code

FP001

9

83809

7

85616

2

D4095-043

Manufactured

No

110

Each

16.0000

Wearplate Assembly

1 11 11/08/12

Location

Loc Qty

Loc Code

FP001

16

83479

7

85615

9

D4095-045

Manufactured

No

110

Each

13.0000

Wearplate Assembly

1 11 11/08/12

Location

Loc Qty

Loc Code

FP001

13

77737

1

84081

4

85614

8

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Shop Packet Print

Page 3

Dart Aerospace Ltd

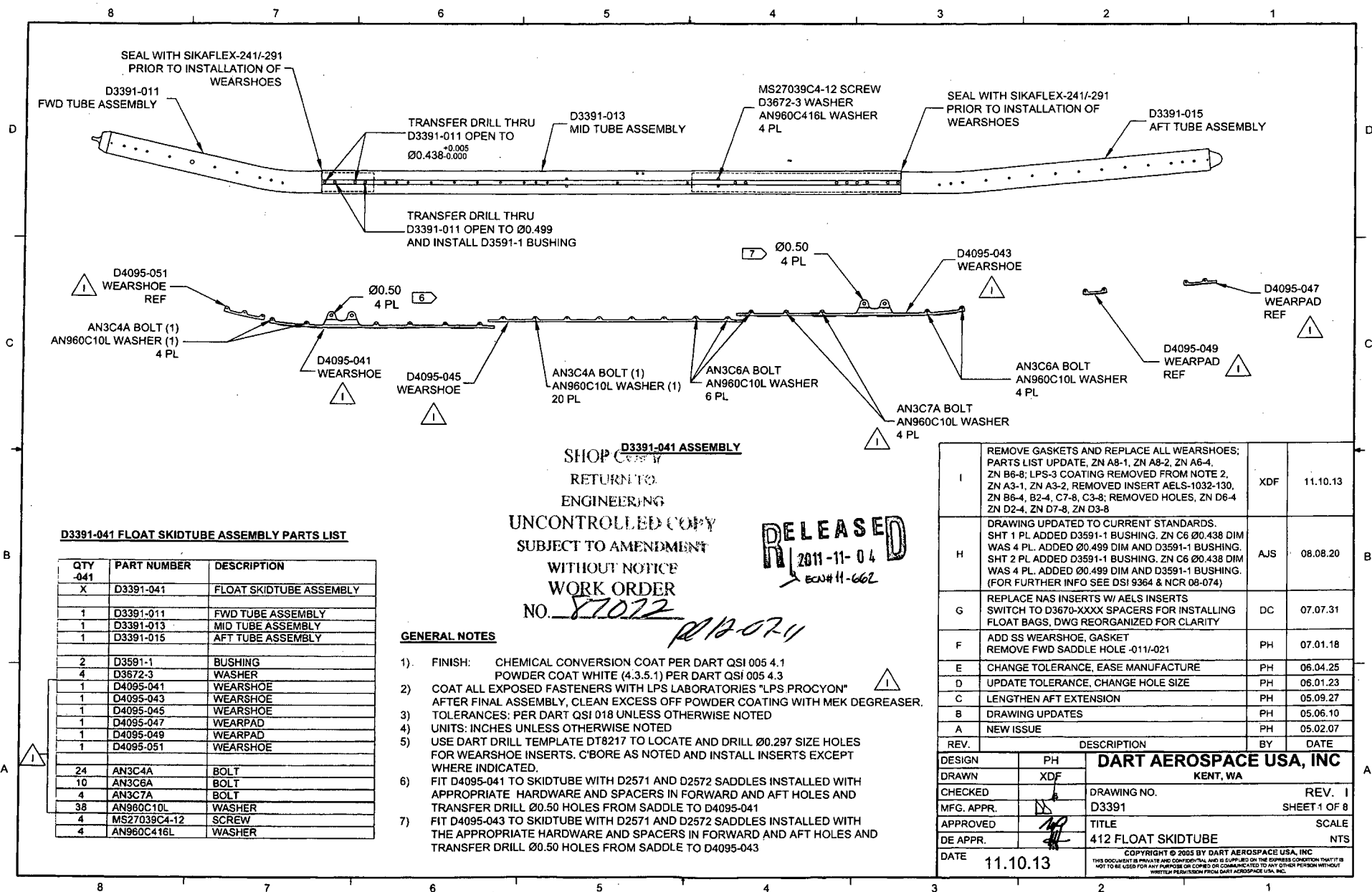
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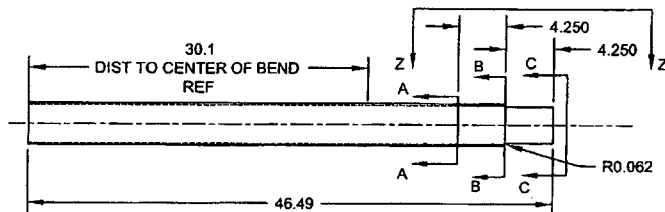
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

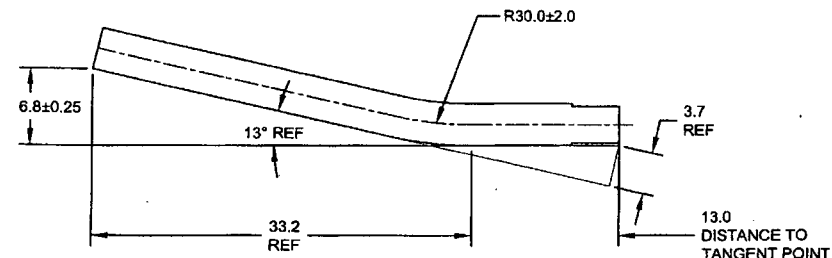
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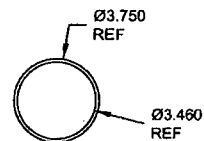




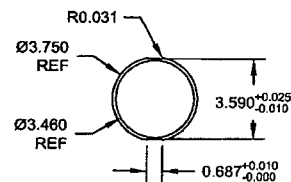
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



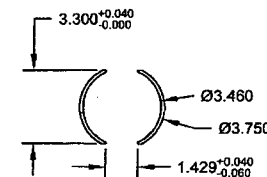
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



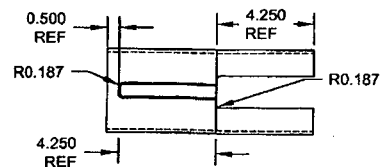
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SECTION B-B
SCALE 2X



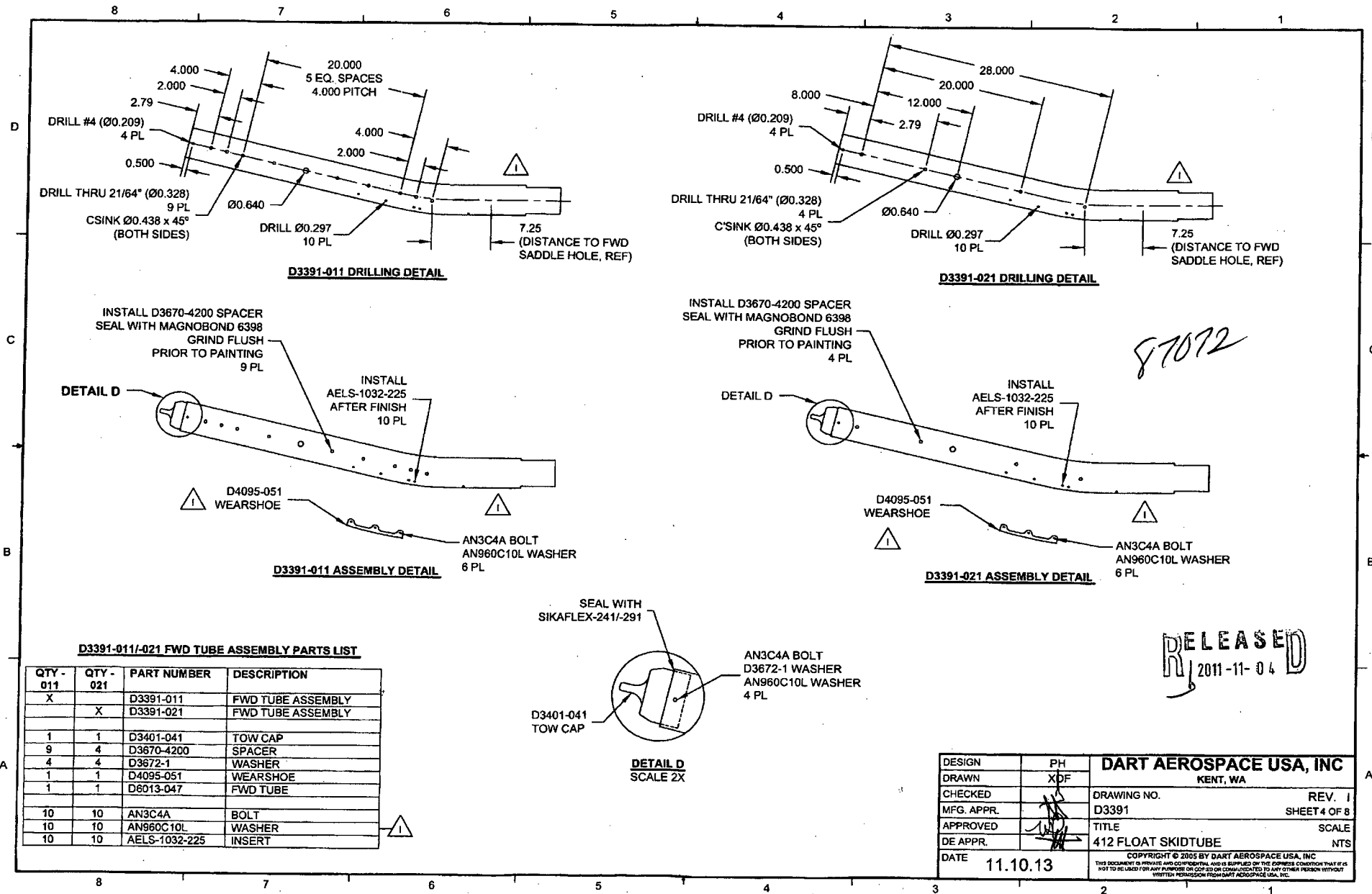
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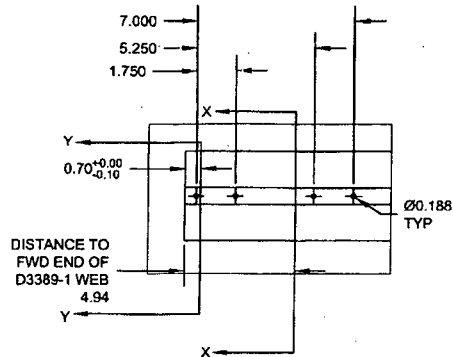


VIEW Z-Z
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82072
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2011-11-04

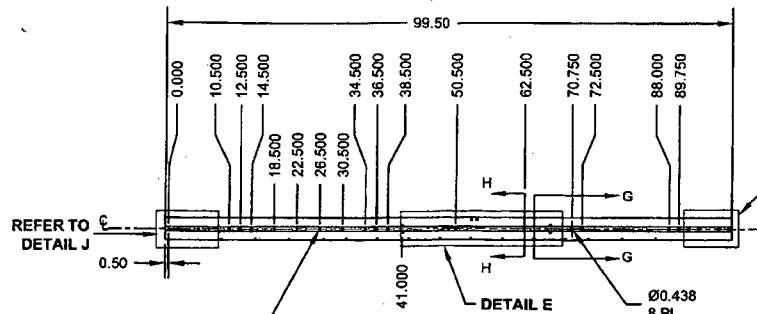
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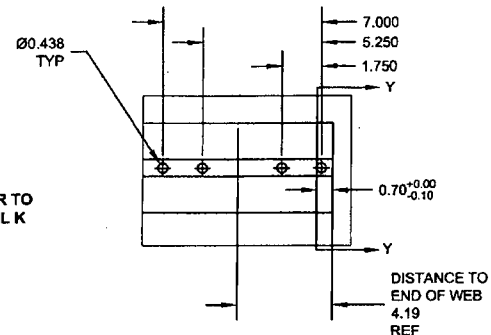
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SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



D3391-013 ASSEMBLY DETAIL

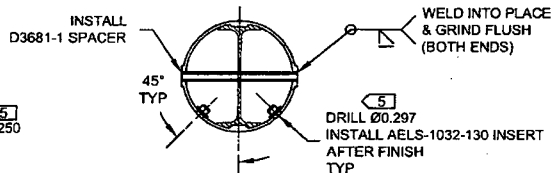
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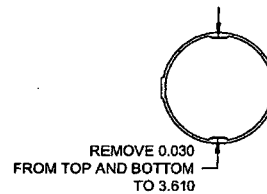
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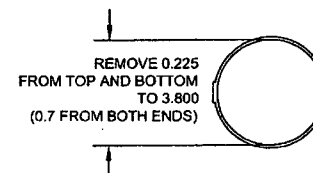
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SECTION H-H
SCALE 5X



SECTION X-X
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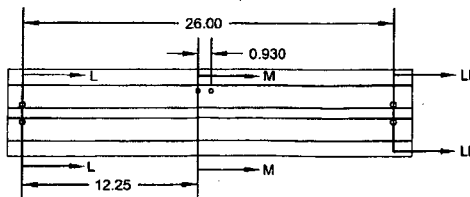
SECTION Y-Y
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

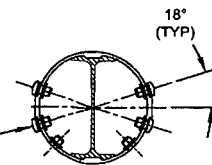
D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

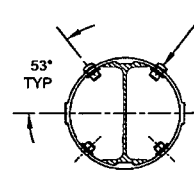


DETAIL E
SCALE NONE

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL

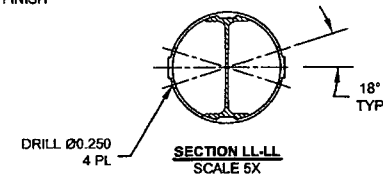


SECTION L-L
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SECTION M-M
SCALE 5X

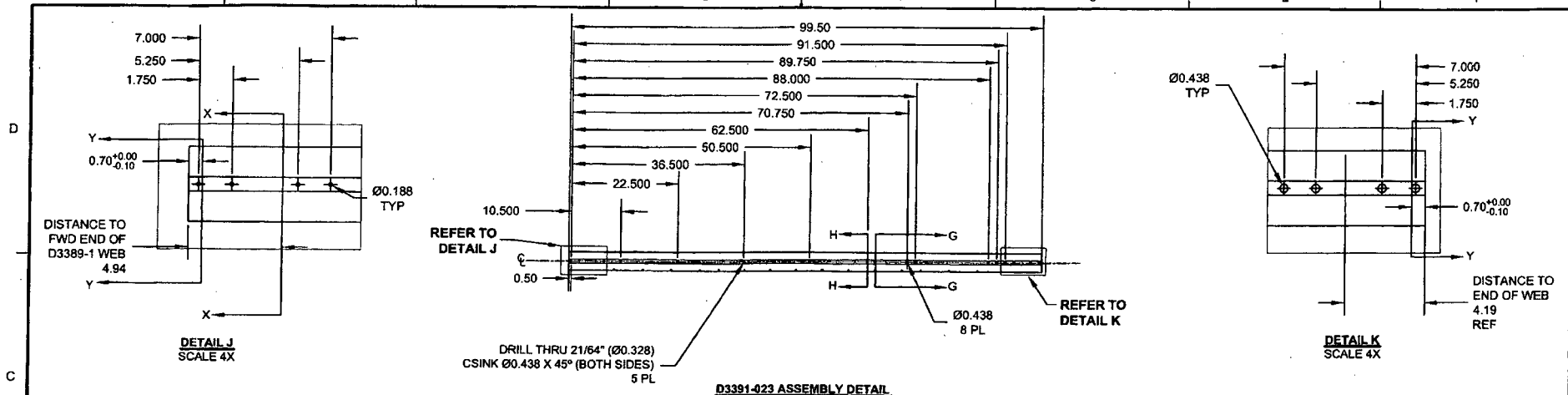
DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



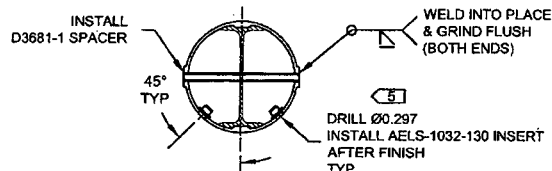
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DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 5 OF 8
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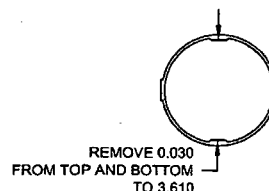
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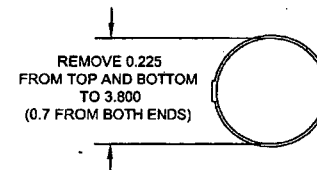
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SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

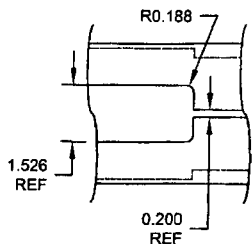
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

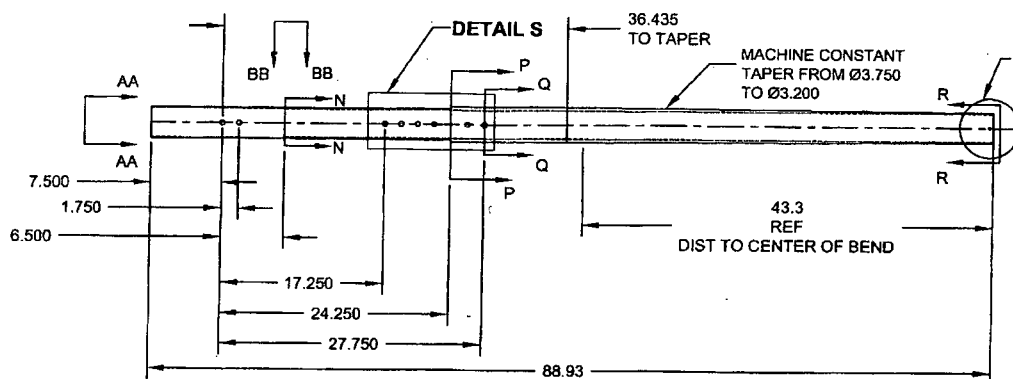
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2011-11-04

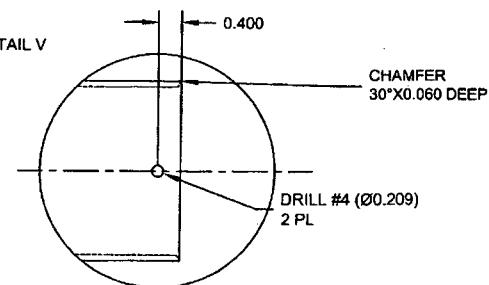
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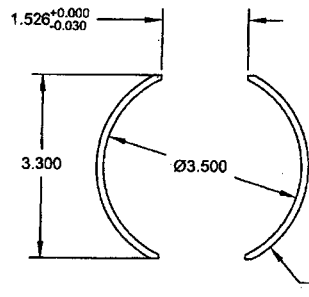


D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

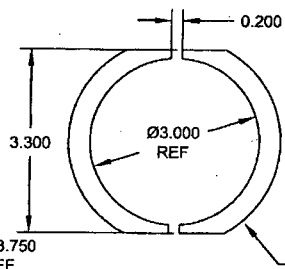


DETAIL V
SCALE 6X

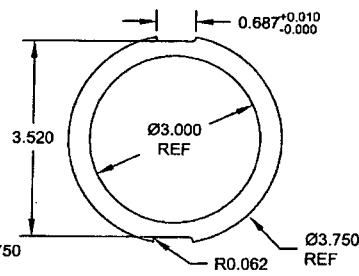
87072



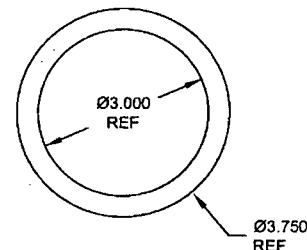
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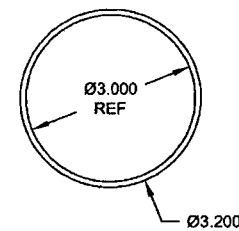
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SCALE 6X



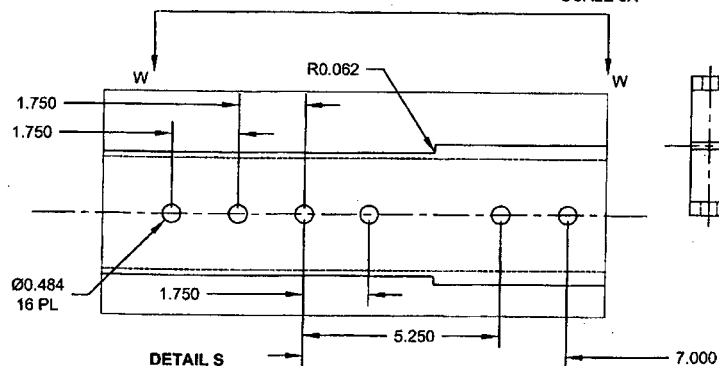
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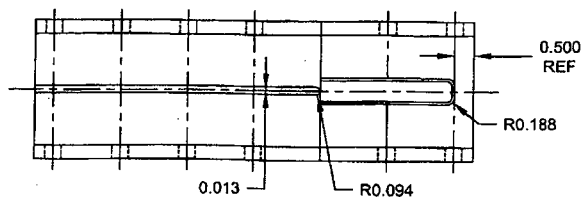
SECTION Q-Q
SCALE 6X



SECTION R-R
SCALE 6X



DETAIL S
SCALE 4X



VIEW W-W
SCALE 4X

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO. D3391	REV. 1
MFG. APPR.			SHEET 7 OF 8
APPROVED			SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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